



## GRADE: ORION® PC/ABSQX7004

Molding Grade PC/ABS

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.13	D792
Melt Flow (260°C/5.0 kg)	10.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	330,000 psi	D638
Tensile Strength @ Yield	8,000 psi	D638
Flexural Modulus	340,000 psi	D790
Flexural Strength @ Yield	12,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	11.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi – Unannealed (0.250 in)	225°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 – .007 in/in	D955

### Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	3.0 - 4.0 hrs at 190 - 230°F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 540°F
Middle Temperature	500 – 550°F
Front Temperature	500 – 580°F
Nozzle Temperature	500 – 580°F
Processing (Melt) Temperature	500 – 580°F
Mold Temperature	165 – 215°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM